

Date: Thursday, 24/07/2008 8:24:44 AM  
 User: Melanie Fauteux

## Process Sheet

*Duplicate*

Customer	CU-DAR001 Dart Helicopters Services				Drawing Name	AFT ADJUSTABLE BLADE SUPPORT ASSY			
Job Number	40609 -1				Part Number	PB674300117			
Estimate Number	13434				Drawing Number	B6743001 P.7			
P.O. Number					Project Number	N/A			
This Issue	24/07/2008 S.O. No. :				Drawing Revision	B1			
Prsht Rev.	NC				Material				
First Issue	17/07/2008	Type	LARGE FAB ASSY		Due Date	24/07/2008	Qty: 5 Um: Each		
Previous Run									
Written By									
Checked & Approved By	MF 08-07-24								
Comment	Est Rev:A 08-06-26 new issue DD verified by:ec								

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001259	Inner Tube	<i>MF 08-07-24</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube batch: 340578	
2.0	PB6743001249	Inner Tube Bushing	<i>MF 08-07-24</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube Bushing batch: M106971	
3.0	PB6743001253	Gusset	<i>MF 08-07-24</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340045=2 40717 =3	
4.0	PB6743001254	Gusset	<i>MF 08-07-24</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340053	
5.0	PB674300171	PB67-43001-71	<i>MF 08-07-24</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-71 batch: 340027	



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Job Number: 40609

Part Number: PB674300117

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

PL 08-07-24

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-24 (S)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/29 (E)

9.0 MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
HELICAL INSERT

M17935

BK

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- tap drill for helicol
- 3- install helicol insert as per dwg

(5)

PL 08-07-30

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/30 (X)

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

13.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 102316

(5X)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M.F 08/07/31



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Job Number: 40609

Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

1:00  
320°F  
1:30

OVEN TEMPERATURE:

(S)

FINISH TIME:

m-f 08/07/31

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 08/07/31

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

20 Degree Cover Plate  
batch: 40094

M 08.08.26

5

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-83  
batch: 40096

M 08.08.26

5

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw  
batch: 18836

M 08.08.26

5

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER  
batch: 106242

M 08.08.26

5

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

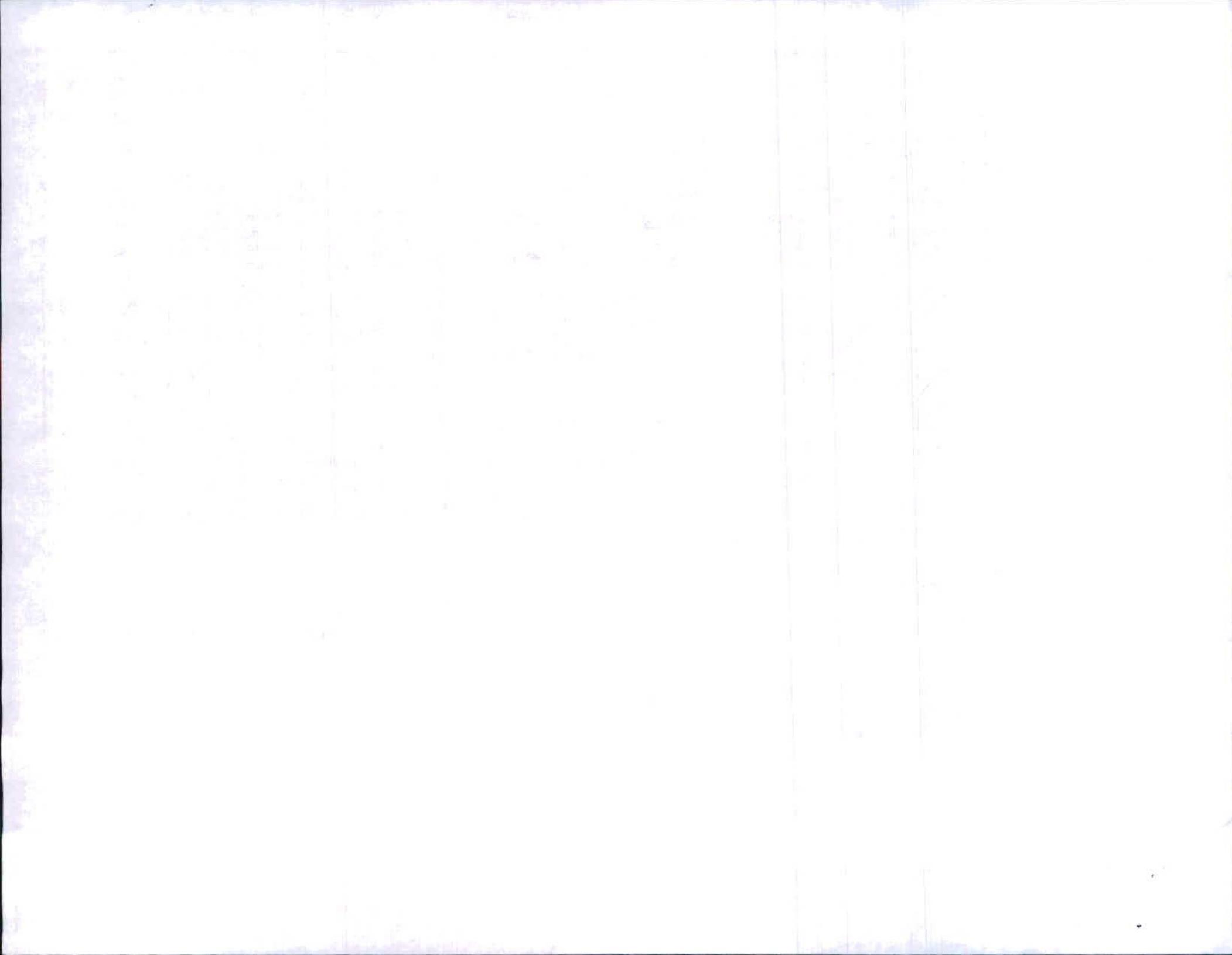


Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support  
2- assemble as per dwg

M 08.08.26

5



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Seq. #: Machine Or Operation:

Description :

20.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/08/26 AF3

Comment: INSPECT WORK TO CURRENT STEP

21.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

39952

22.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26 AFJ

Job Completion



u 08.08.26

